

Work Order ID 52756

October 14, 2009 9:05:33 AM



Page 1

Item ID: D3953-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Bracket

Start Date: 14/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

RL

Date: *09-10-14*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3953

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3953

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

B 9-10-22

09/10/20

14

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 9-10-22

Work Order ID 52756

October 14, 2009 9:05:33 AM



Page 2

Item ID: D3953-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Bracket

Start Date: 14/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	=> 80210/26			(14)	0		
130 Small Fab Small Fab	Memo 1- CHAMFER HOLE AS PER DWG 2- DEBURR IF NECESSARY	0.00 0.00				809/10/27 (14)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	=> 80210/27			(14)	0		

Work Order ID 52756

October 14, 2009 9:05:33 AM



Page 3

Item ID: D3953-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Bracket

Start Date: 14/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 21/10/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

09/10/28 (14)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/29

12/09-10-28

Picklist Print

October 14, 2009 9:05:39 AM

Page 1

Work Order ID: 52756



Parent Item: D3953-1



Parent Item Name: Gas Spring Bracket



Start Date: 14/10/2009

Required Date: 21/10/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	128.1312	0.3373	4000		
304/316 0.125 Sheet												189-10-18

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

128.1311979

111018

0.13119789

112663

128

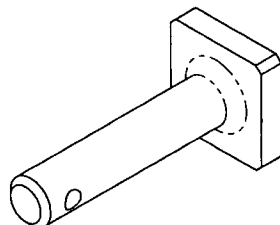
111018

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

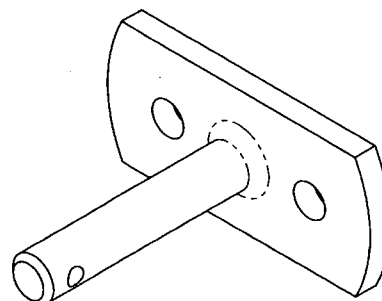
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 32756
BS 09-10-14



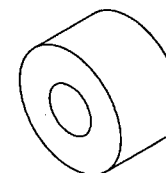
D3953-1 GAS SPRING BRACKET
(FULL LID)



D3953-3 GAS SPRING STUD, LID



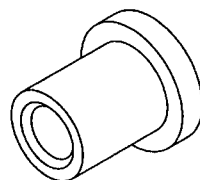
D3953-5 GAS SPRING STUD, BASE



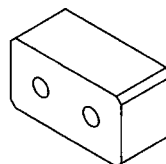
D3953-7 GAS SPRING SPACER



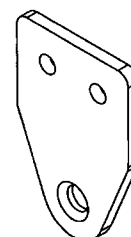
D3953-9 GAS SPRING WASHER



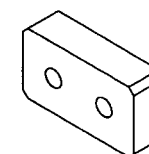
D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER
(FULL LID)



D3953-15 GAS SPRING BRACKET
(SPLIT LID)



D3953-17 GAS SPRING SPACER
(SPLIT LID)

RELEASED
2009 -10- 08
mp

A		NEW ISSUE		DESCRIPTION		AJS	09.07.27
REV.						BY	DATE
DESIGN		AJS		DART AEROSPACE LTD			
DRAWN		AJS		HAWKESBURY, ONTARIO, CANADA			
CHECKED		<i>[Signature]</i>		DRAWING NO.			REV. A
MFG. APPR.		<i>[Signature]</i>		D3953			SHEET 1 OF 4
APPROVED		<i>[Signature]</i>		TITLE			SCALE
DE APPR.		<i>[Signature]</i>		GAS SPRING LID COMPONENTS			NTS
DATE		09.07.27		<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

SHOP COPY

RETURN TO

ENGINEERING

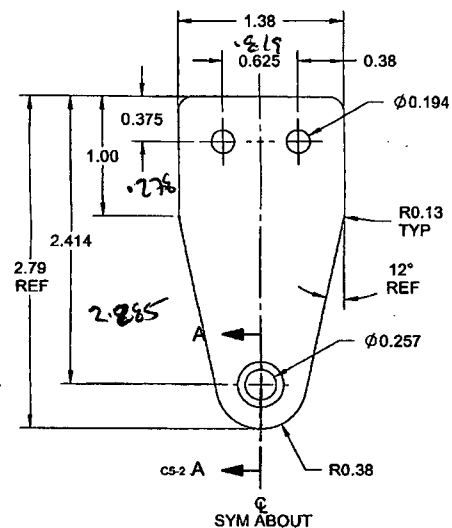
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

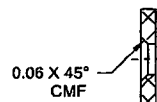
WITHOUT NOTICE

WORK ORDER

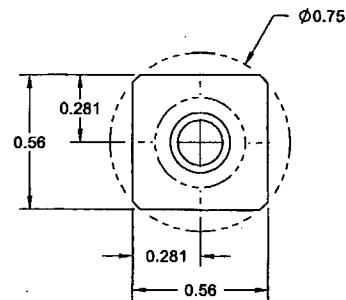
52756



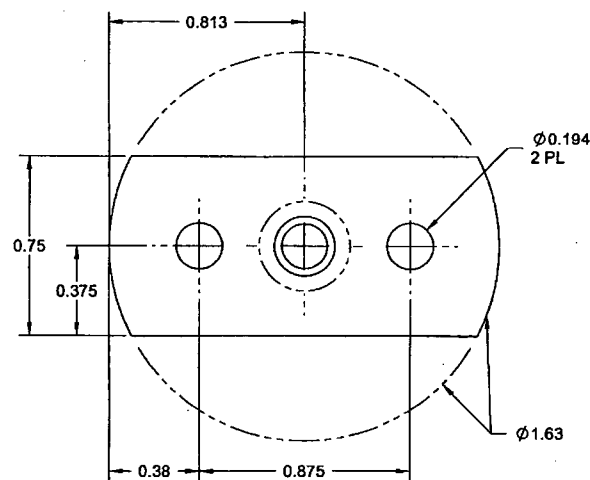
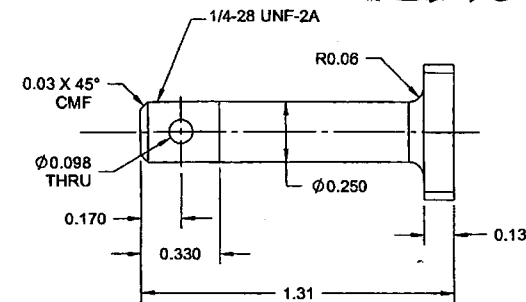
D3953-1 GAS SPRING BRACKET
(FULL LID)



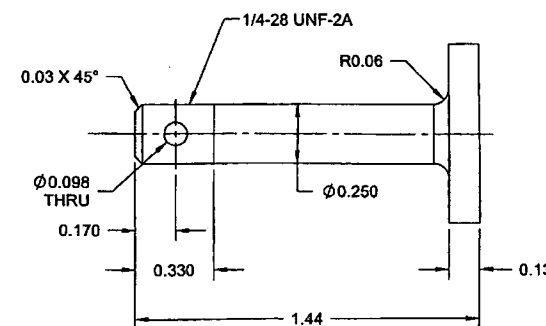
SECTION A-A C7-2



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE



NOTES:

1) MATERIAL -1: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S

-3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

OR: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.11 lbs
-3: 0.03 lbs
-5: 0.06 lbs

RELEASED
2009-10-08

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3953	SHEET 2 OF 4
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	GAS SPRING LID COMPONENTS	NTS
DATE	09.07.27	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SHOP COPY

RETURN TO

ENGINEERING

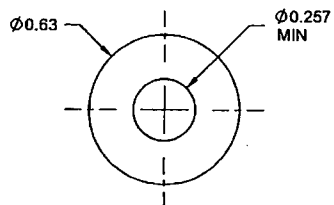
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

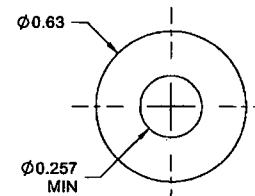
WITHOUT NOTICE

WORK ORDER

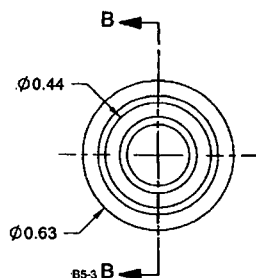
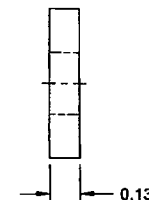
NO. 52756



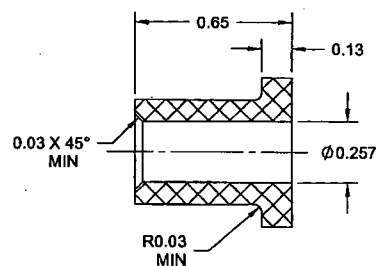
D3953-7 GAS SPRING SPACER



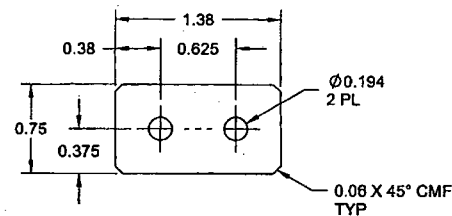
D3953-9 GAS SPRING WASHER



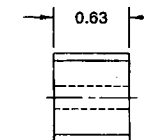
D3953-11 GAS SPRING SPACER



SECTION B-B B7-3



D3953-13 GAS SPRING SPACER



NOTES:

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

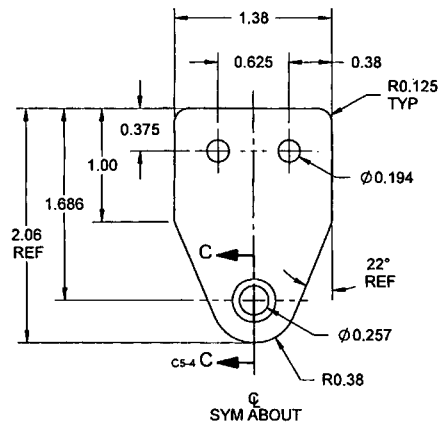
-13: 0.17 lbs

RELEASED
2009-10-08

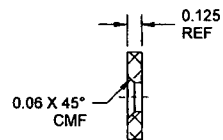
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS NTS	
DATE	09.07.27	COPYRIGHT © 2009 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SHOP COPY

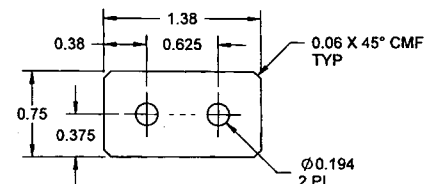
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 5270-8



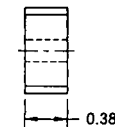
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



SECTION C-C C7-4



D3953-17 GAS SPRING SPACER
(SPLIT LID)



NOTES:

1) MATERIAL -15: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs

RELEASED
2009-10-08
WJD

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
DATE	09.07.27	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	